

Date: Wednesday, 04/07/2007 7:03:49 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : ROUND BILLET, ALUMINUM
Job Number : 33275	
Estimate Number : 12286	
P.O. Number : N/A	Part Number : D6103003
This Issue : 04/07/2007 S.O. No. : N/A	Drawing Number : D6103 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 30170	Material : N/A
Written By : _____	Due Date : 11/07/2007
Checked & Approved By : _____	Qty: 60 Um: Each
Comment : Est Rev:A New Issue 06-02-09 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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Comment: PURCHASING

Issue P/O: 4087 c207/07/04

a) Description: Alluminum round billet

b) Ø3.500" x 12.500" long

c) Tolerance on all dimensions are +0.030"/-0.000"

d) Material: 7075-T7351 (QQ-A-225/9)

Material certification required

(66)

2.0	D6103003P	round alum billet
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 60.0000 Each(s)
 alum billet

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

c27/7/14 (66)

4.0	QC6	DIMENSIONAL CHECK
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Comment: DIMENSIONAL CHECK

86 07.07.17 66

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: CNC

86 07.07.24 66

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ED Date: 07/07/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 04/07/2007 7:03:49 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ROUND BILLET, ALUMINUM

Job Number: 33275

Part Number: D6103003

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



66

Comment: FINAL INSPECTION/W/O RELEASE

07/07/04

Job Completion



U 07-07-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

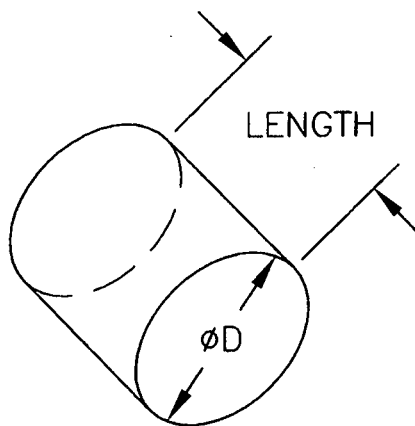
NOTE: Date & initial all entries



DESIGN P/H	DRAWN BY P/H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D6103	Rev. B SHEET 1 OF 1
DATE 06.01.31		TITLE ROUND BILLET, ALUMINUM	SCALE NTS
A	01.04.10	NEW ISSUE	
B	06.01.31	ADD D6103-003	

SPECIFICATION CONTROL DRAWING

RELEASED
06.02.07 [Signature]



PURCHASE MATERIAL ACCORDING TO THE FOLLOWING TABLE. SPECIFY ALLOY, DIAMETER x LENGTH (+0.030/-0.000) AS SHOWN.

TOLERANCE ON ALL DIMENSIONS IS +0.030/-0.000.

ALL DIMENSIONS ARE IN INCHES.

Part No.	Alloy	D (Diameter)	Length
D6103-001	7075-T6/T651 (QQ-A-200/11 OR QQ-A-225/9)	Ø3.250	12.50
D6103-003	7075-T7351 (QQ-A-225/9)	Ø3.500	12.50

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NO. COM-ORD. NO. NO. TRANS. DE-FROM
1 554016 962770 01



Métaux Castle®

CERTIFICATION

A.M. CASTLE & Co. (Canada) Inc.

EXPÉDIÉ

DATE CHARGED-LOADED
12 JUL. 2007

NO. COM-ORD. NO.
554016

POIDS TOTAL JOURNÉE-TOT. DLY. W

ACQUISITION CLIENT-CUSTOMER REQUISITION NO.

NO. COM. CLIENT-CUST. ORD. NO.

COMPTÉ-ACCT.

VEND. SLS

TERR.

EXPÉDIÉ PAR-SHIP VIA

***** TRANSHIPMENT *****

BUYER-PURCHASING AGENT

TELEPHONE

H/C TAXE

NO. COM ORD

REGION LIVRAISON-DEL ZONE

F.A.B.-F.O.B.

BILL

NO. FEVILE/EMBALLAGE-D/L NUMBER

RE A-SHIP TO:

VENDU A-SOLD TO:

DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

INFORMATION CREDIT-CREDIT INFORMATION

ROUTE

01-NL-07/09

31-NL-07/11

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

INSTRUCTIONS/LIVRAISON-DELIVERY

INSTRUCTIONS LIVRAISON (CONT.)-DELIVERY (CONT'D.)

***** TRANSHIPMENT *****

PRIOR DIST/ORD: 01 962770

DESCRIPTION - ITEM 1

3.5000 RD 7075-T7351 ALUM BAR CF 12.50"

BLACK

CERTIFICATE OF CONFORMANCE

INSTRUCTIONS

TOL + 1/16" -0"

CUT IN MONTREAL

CHICAGO: SHIP 6 FULL BARS

PRIOR DIST/ORD: 01 962770

COULÉE INFO-HEAT INFO

QTE-QTY

20089128

L.B.

INSTRUCTIONS (CONT'D.)

66x12.50"

QTE/UNITE COM.-ORDERED

PCES/COM-ORD

POIDS COM.-WT. ORDERED

66 PCS PCS

801

BALLOTS-BUNDLES

PCES/PD EXP. SHP.

POIDS EXP.-WT. SHIPPED

1 66

788

FORME-SHAPE

I.A.C.

8808

11.640FT

ENT-WI

N3

WEIGHT FOR SHIPPING PURPOSES ONLY. SEE INVOICES FOR ACCURATE BILLING WEIGHT. PLEASE SIGN AND DATE DRIVER'S COPY FOR RECEIPT OF MATERIAL AND, IF CHECKED, TEST REPORTS:

DESCRIPTION - ITEM 2

INSTRUCTIONS

1 Box

COULÉE INFO-HEAT INFO

QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM.-ORDERED

PCES/COM-ORD

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PD EXP. SHP.

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

ENT-A

TERMS AND CONDITIONS OF SALE

SEE DISCLAIMERS AND LIMITATIONS ON THE REVERSE SIDE

DESCRIPTION - ITEM 3

INSTRUCTIONS

COULÉE INFO-HEAT INFO

QTE-QTY

INSTRUCTIONS (CONT'D.)

QTE/UNITE COM.-ORDERED

PCES/COM-ORD

POIDS COM.-WT. ORDERED

BALLOTS-BUNDLES

PCES/PD EXP. SHP.

POIDS EXP.-WT. SHIPPED

FORME-SHAPE

I.A.C.

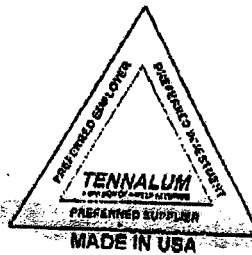
ENT

ALL EXCEPTIONS FOR SHORTAGE OR DAMAGE MUST BE NOTED ON THE DRIVER COPY & CUSTOMER COPY OF THE DELIVERY RECEIPTS & SIGNED BY THE DRIVER & CUSTOMER. COPY OF SUCH RECEIPT PROPERLY NOTED MUST BE SUBMITTED WITHIN 10 DAYS WHEN CREDIT IS REQUESTED.

NOM (LETTRE MOULÉE)-NAME (PRINT ONLY)

KAISER ALUMINUM FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://KaiserEngProd.com>

CUSTOMER PO NUMBER: 01-28294		CUSTOMER PART NUMBER: 8808		PRODUCT DESCRIPTION: Cold Finished Round	
KAISER ORDER NUMBER: 625419	LINE ITEM: 1	SHIP DATE: 02/26/2007	ALLOY: 7075	TEMPER: T7351	
WEIGHT SHIPPED: 982 lbs.	QUANTITY: 7 pcs.	S/L NUMBER: 25790	DIAM/DAF/THKNS: 3.506 in.	WIDTH: 0.000 in.	LENGTH: 144.0 in.
SHIP TO: A M Castle & Co 3400 No. Wolf Road Franklin Park, IL 60131 USA			SOLD TO: A M Castle & Co 3400 No. Wolf Road Franklin Park, IL 60131 USA		

Test Code: 1000 AC

Actual Physical Properties

Lot Number	LONG. UTS ksi	LONG. YTS ksi	LONG. ELONG. %	COND % IACS
20089128	70.5	59.1	17.0	39.4

Chemical Composition, WT. % (Aluminum Remainder)

	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHERS EACH	OTHERS TOTAL	Lot
Actual	0.10	0.30	1.4	0.04	2.6	0.21	5.8	0.02			20089128
Max	0.40	0.50	2.0	0.30	2.9	0.28	6.1	0.20	0.05	0.15	
Min			1.2		2.1	0.18	5.1				

Specifications

Standard: ISO 9001, ASTM B211-03, AMS 4124D, AMS-QQ-A-225/9 Non-Standard: A97075-11-9

CASTLE METALS FP
DATE REC'D 3-1-7 IAC 8808
APPROVED BY TR

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

John Rennekamp

Plant Serial: 83918

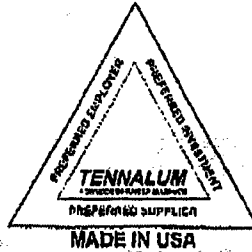
Kaiser Order Number: 625419

Line Item: 1

KAISER ALUMINUM

FABRICATED PRODUCTS

Tennalum
PO Box 669
Jackson, TN 38302
731-423-2811



CERTIFIED TEST REPORT
<http://KaiserEngProd.com>

Miscellaneous Notes

Made in USA

This material was melted and manufactured in the USA. Mercury is not a normal contaminant in aluminum alloys. Neither mercury nor any of its compounds were utilized by Kaiser Aluminum in the manufacture of this material. This material meets the requirements of (cold finished) T73 temper and QQ-A-225/9E (CANCELLED). NAFTA - YES.

CERTIFICATION

Kaiser Aluminum & Chemical Corporation ("Kaiser") hereby certifies that the metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms and conditions of sale. Test reports are on file, subject to examination.

John Rennekamp, Quality Manager

Plant Serial: 83918

Kaiser Order Number: 625419

Page 2 of 2

Line Item: 1